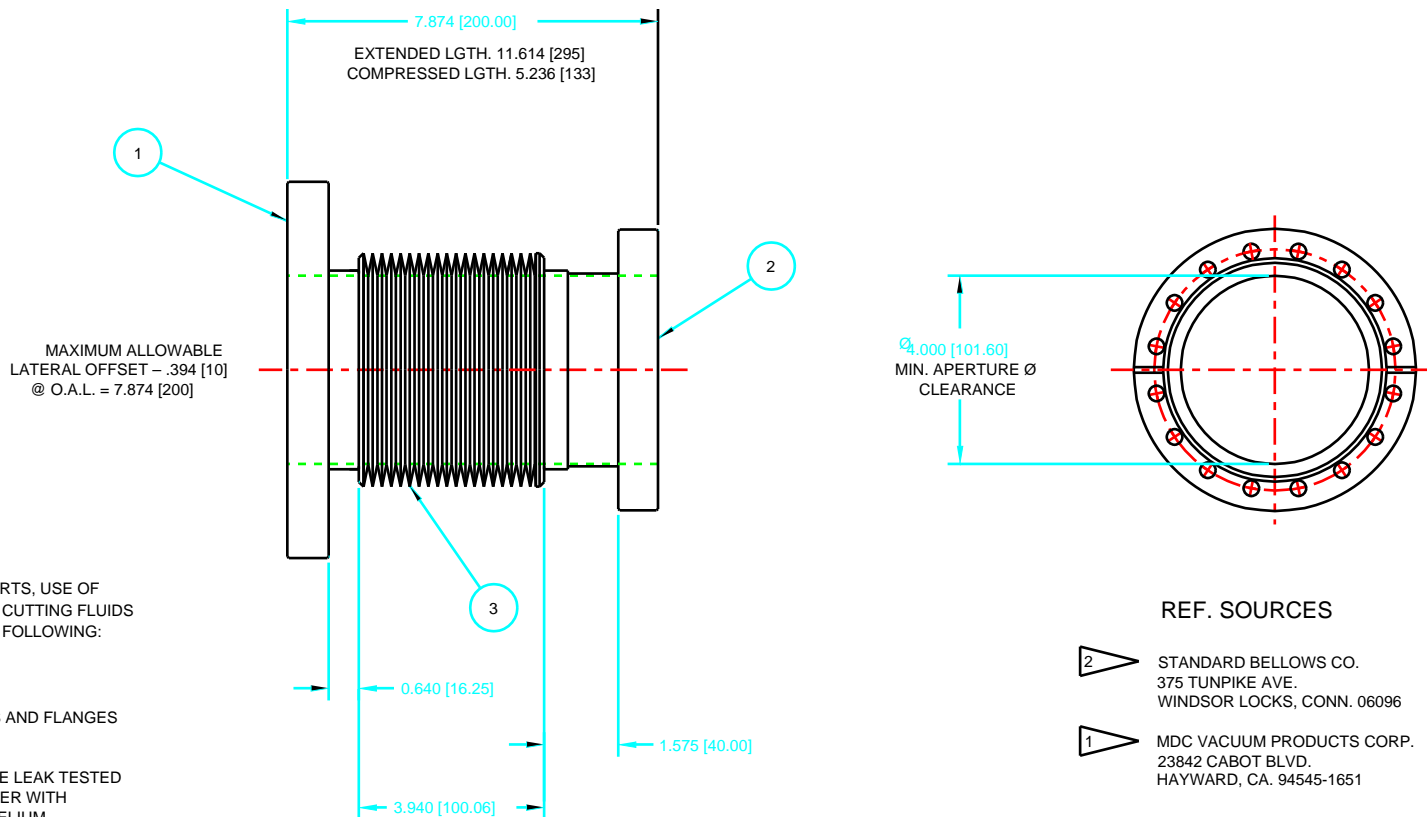


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- NOTES:
- WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
 - ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL
 - BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.
FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
 - KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 - DIMENSIONS IN [] ARE MILLIMETERS



3		ST'D. BELLOWS CAT. #497 - 400 - 6 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100026	6" CF. ROTATABLE FLANGE		1
1	MDC'S CAT. #110030	8" CF. NONROTATABLE FLANGE 4" I.D.		1
ITEM	SYM/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS	ANGLES			
.1	.03 [7620]			.25
.XX	.01 [0.25]			
.XXX	.005 [0.127]			
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ.				
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. 104.				
PAINTING TO BE IN ACCORDANCE WITH LATEST ASST. 104.				
DO NOT SCALE DRAWING				
THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY				
A14775				
DRAWN BY	DATE	CHEF DESIGN ENGINEER	DATE	TITLE
MUSCIA	11/17/83	OP LEADER		ADVANCED PHOTON SOURCE
CHECKED BY		PROJECT MGR		V2 - 87 WELDED BELLOWS ASSY.
DESIGNER		APPROVED/RELEASED		8" - 6" CF. 4" I.D. X 200mm
MUSCIA				
RESPONSIBLE ENGINEER				
MATERIAL SEE PARTS LIST				
SCALE HALF SIZE				
SHEET 1 of 1				
DRAWING NUMBER 4105090702-870000-00				

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

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